

Date: Friday, 23/05/2008 9:56:30 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEARPAW		
Job Number	: 39442			Part Number	: D2995		
Estimate Number	: 11647			Drawing Number	: D2995 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 23/05/2008	S.O. No.	:	Drawing Revision	: A1		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 12/06/2008		
Previous Run	: 28715			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	: JUO 08.5.23						
Comment	: Est A 01.03.07 New Issue EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black <i>Batch L frag.</i>
		Comment: Qty.: 2.7777 sf(s)/Unit Total : 27.7770 sf(s) Pick: Material: Black UHMW 1" Batch <u>M108013</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <i>H.A 08/06/08</i>
		Comment: HAAS CNC VERTICAL MACHINING #1 Cut blank: 19.50" x 20.00" Inspect material for defects or damage prior to machining Machine as per folio FA119 Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>H.A / QM 08/06/08</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>J.L 08/06/10</i>
		Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>AS 08/06/10 (XIG)</i>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>PPP:39425</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:56:30 AM
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Drawing Name: BEARPAW

Job Number: 39442

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/06/10 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.06.10

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DART AEROSPACE LTD	Work Order:	39442
Description: Bearpaw	Part Number:	D2995
Inspection Dwg: D2995 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	0.618	✓			
0.250	+/-0.010	0.249	✓			
R0.25	+/-0.030	R 0.25	✓			
0.25 x 45°	+/-0.030 x 0.5°	0.245X45°	✓			
5.86	+/-0.030	5.864	✓			
0.950	+/-0.010	0.952	✓			
0.433	+/-0.010	0.432	✓			
19.00	+/-0.030	19.00	✓		tape	
4.25	+/-0.030	4.253	✓			
3.63	+/-0.030	3.625	✓			
7.375	+/-0.010	7.375	✓			
11.625	+/-0.010	11.625	✓			
0.38	+/-0.030	0.385	✓			
3.081	+/-0.010	3.071	✓			
17.73	+/-0.030	17.715	✓			
19.34	+/-0.030	19.34	✓		tape	
Ø0.260	+0.006/-0.001	Ø0.260	✓			
0.30	+/-0.030	0.308	✓			
Ø0.93	+0.004/-0.001	Ø0.930	✓			

Measured by:	N.A / amk	Audited by:	DTP	Prototype Approval:	N/A
Date:	08/06/09	Date:	08/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	PZ

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QA: N/C Closed: _____ Date: _____

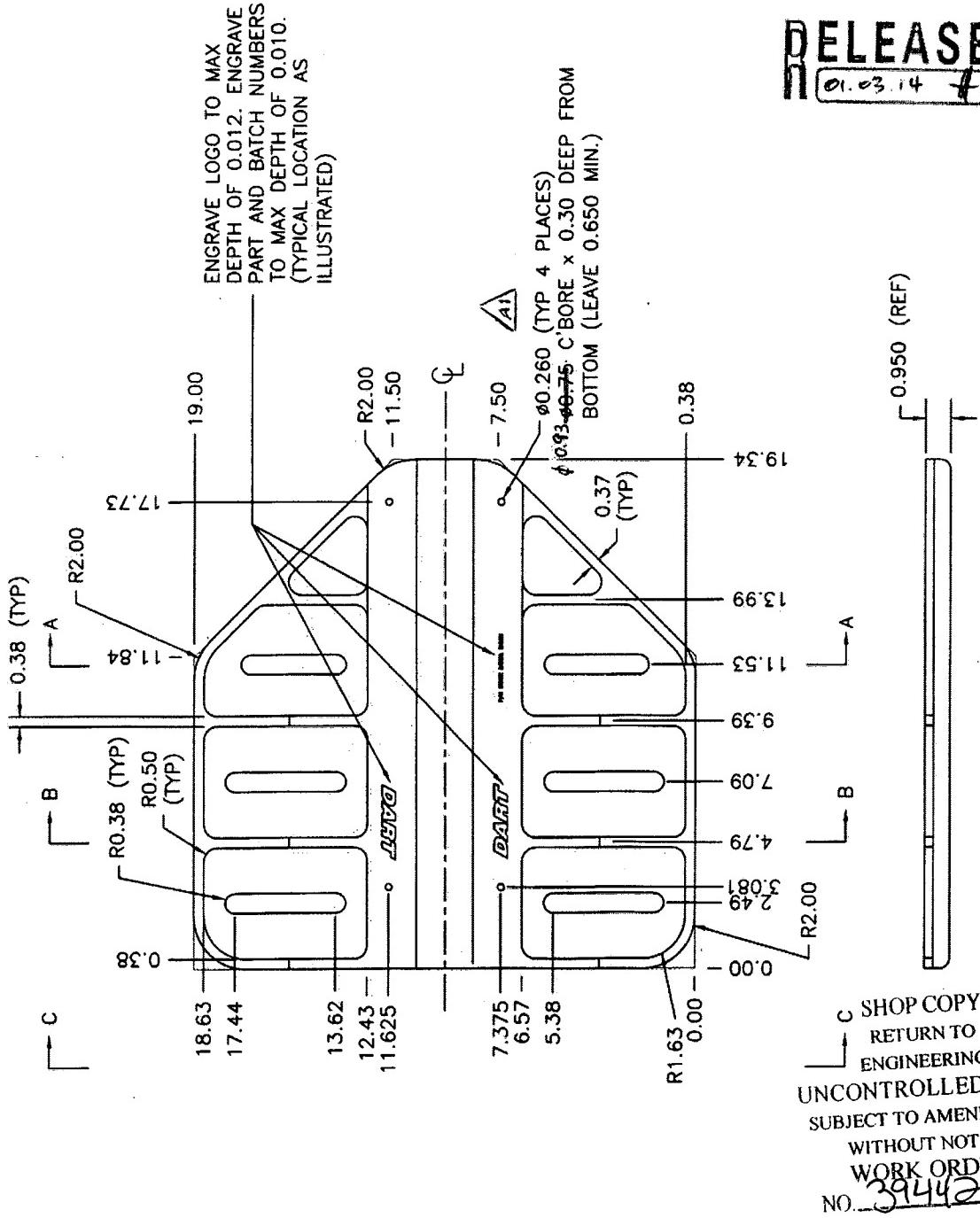
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2995	REV. A	SHEET 1 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:6	
A	01.02.23	NEW ISSUE		
AI	RF 03-01-06	\$0.93 WAS \$0.75		

RELEASED
01-03-14



BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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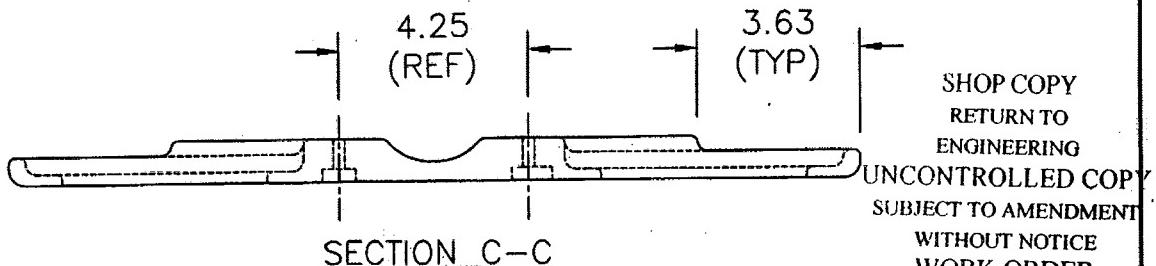
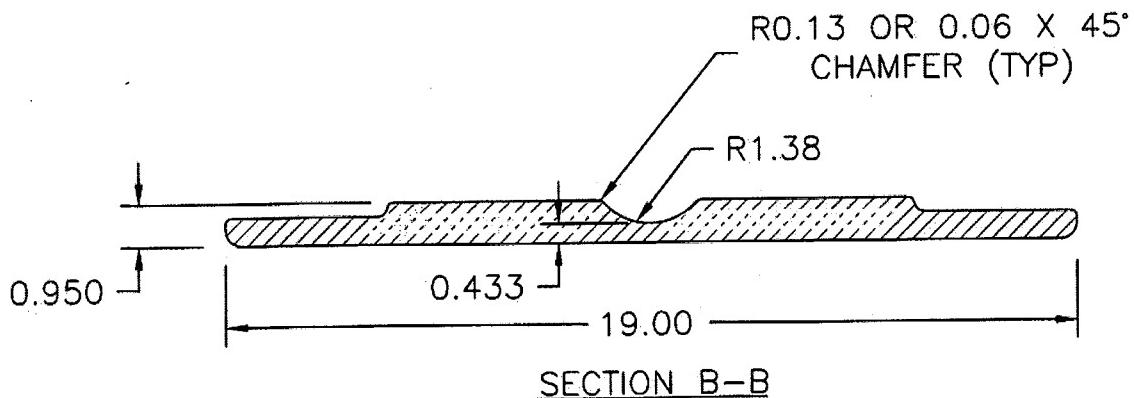
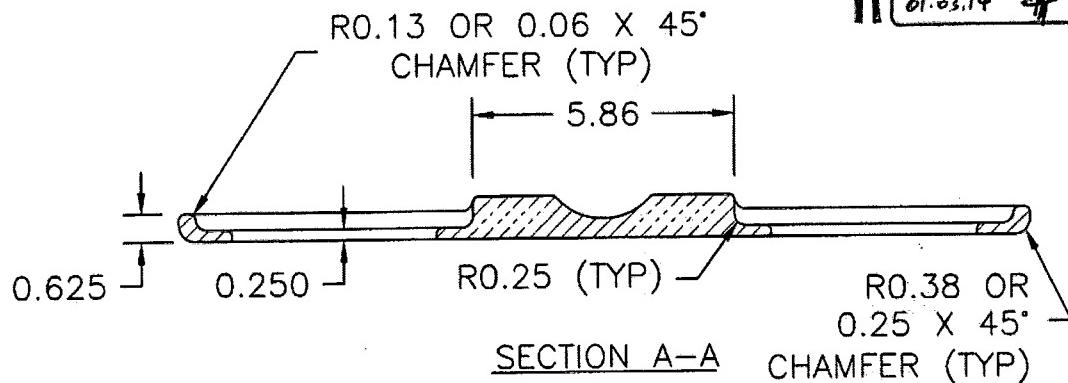
QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23	TITLE BEARPAW	SCALE 1:4	

RELEASED
01-03-14 *A*

W/O:		WORK ORDER CHANGES					
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